

Work Order ID 69951

Wednesday, May 25, 2011 8:07:28 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 5/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11/05/25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

3 DL 11/05/30

M11385 / M117456 BE 11/05/31

BE 11/05/31

} DL 11/06/03

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublog

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x1

11/04/09

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-6-9

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

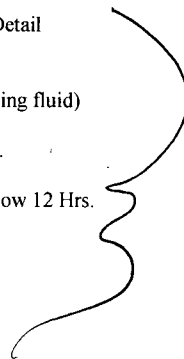
Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)								
	2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.								
	4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting								
	Start Date: <u>11/06/09</u> Time: <u>3:00 PM</u>								
	Finish Date: _____ Time: _____								
	A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M116945</u>								
	Sikaflex expiry date: <u>12/01/15</u>								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									



BE 11/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod ☒ M12860

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

1 0 BE 11/06/13

BB 11/06/13

BE 11/06/14

BB 11/06/13

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 11/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			8 11/06/14						
190  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.	0.00 0.00							
			1 0 11/06/15						
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:20 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:50	0.00 0.00							
			1X 0 M 11/06/16						

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d 92 11/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ 11117516Sikaflex expiry date: 15/01

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

✓ A/R ☐ Sikaflex-291 ☐ 11117516Sikaflex expiry date: 15/01

✓ 6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 11117863

1	0	11117516	128
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Work Order ID 69951

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Customer:





Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		8 1106130					
240  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8 1106130					
250  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location: <u>PPP 71523</u> (311) PPP Rev: _____	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Work Order ID 69951

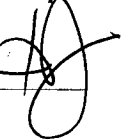
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Item ID: D206-642-341 Accept  Setup Start 
Revision ID:
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Start Date: 5/24/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 5/31/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/2/11 
mf 11-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, May 25, 2011 8:07:35 AM

Page 1

Work Order ID: 69951

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube







Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 	NAS1149D0463J	Purchased	No				Each	0.0000	1				
Washer							1117460			(x1) 11/06/28			
CCR264SS3-3 		Purchased	No				Each	119.0000	2				
Cherry Rivet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-B		2							
				113973		2							
				ST311		117							
				117086		117				2.		11/06/1	
CR3212-4-03 		Purchased	No				Each	1,250.000	2				
Cherry Rivet													

1117460

11/06/28

2.

11/06/13

2

11/06/13

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Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2620 Manufactured No

Each 7.0000

1



Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

7

62684

3

68135

4

D2647 Manufactured No

Each 34.0000

1



Cap

Location

Loc Qty

Loc Code

LG002

34

55352

34

D2649 Manufactured No

Each 87.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

75

68224

75

LG001

12

65317

1

68507

11

D2654-5 Manufactured No

Each 1.0000

1



Web

Location

Loc Qty

Loc Code

LG

1

67675

1

70229

OK
11/05/30

BEN 11/05/31

BE 11/06/13
B 70394 19

OK
11/06/22

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Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

Each 19.0000 1



Nut Plate

70088

Location

Loc Qty

Loc Code

ST020

19

55366

19

MS27039C1-08 Purchased No

Each 1,048.000



SCREW

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

1047

116373

47

117291

1000

ALS4-1032-130 Purchased No

220 Each 2,378.000 54



Insert

Location

Loc Qty

Loc Code

ST281

378

117331

378

ST282

2000

117717

2000

AN960C10L NAS1149C0332 Purchased No

220 Each 0.0000 54



washer

1117887

(x54) 11/06/28

AN960JD10L NAS1149D0332J Purchased No

220 Each 0.0000 2



Washer

1117291

(x2) 11/06/28

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Shop Packet Print

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Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No

220 Each

38.0000

1

1



Aft Cap



24

11/06/28

Location

Loc Qty

Loc Code

FP006

37

62678

37

X1

FP-4

1

69019

1

D2651-1 Manufactured No

220 Each

272.0000

14

14



Plug



24

11/06/28

Location

Loc Qty

Loc Code

fpa

121

69018

121

FP-A

151

57869

7

66445

10

67263

12

67760

122

X14

D2651-3 Manufactured No

220 Each

600.0000

14

14



O-Ring



24

11/06/28

Location

Loc Qty

Loc Code

FP-A

600

61962

156

66956

444

X14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:07:36 AM

Page 5

Work Order ID: 69951

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-11 Manufactured No 220 Each 10.0000 1 1
Wearshoe
JL 11/06/28

Location Loc Qty Loc Code

FP019 10
68362 10

D3535-23 Manufactured No 220 Each 28.0000 1 1
Wearshoe
JL 11/06/28

Location Loc Qty Loc Code

FP021 28
66236 2
67594 13
68342 13

D3535-35 Manufactured No 220 Each 17.0000 1 1
Wearshoe
JL 11/06/28

Location Loc Qty Loc Code

FP018 17
65926 1
67598 6
68348 10

D3536-11 Manufactured No 220 Each 15.0000 1 1
Gasket
JL 11/06/28

Location Loc Qty Loc Code

FP011 15
46649 1
46715 4
65574 10

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:07:36 AM

Page 6

Work Order ID: 69951

Parent Item: D206-642-341


Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011

Required Date: 5/31/2011


Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No 220 Each 21.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP011	21	
43406	1	
<u>66560</u>	20	


del 11/06/28

D3536-35 Manufactured No 220 Each 13.0000 1 1

 Gasket

Location	Loc Qty	Loc Code
FP012	13	
66237	1	
67599	12	

B69755


xl

D3537-1 Manufactured No 220 Each 27.0000 6 6

 Wearpad

Location	Loc Qty	Loc Code
FP017	27	
63313	2	
66804	21	
66935	4	

B69778

xl

D3537-3 Manufactured No 220 Each 8.0000 1 1

 Wearpad

Location	Loc Qty	Loc Code
FP017	8	
35697	1	
66230	7	

B69792

xl

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Page 6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 8:07:37 AM

Page 7

Work Order ID: 69951

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

65.0000

1

1



ju 11/06/28

Screw

Location

Loc Qty

Loc Code

FP-A

30

115460

30

xl

ST292

35

115460

35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69951

PP11-05-25

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

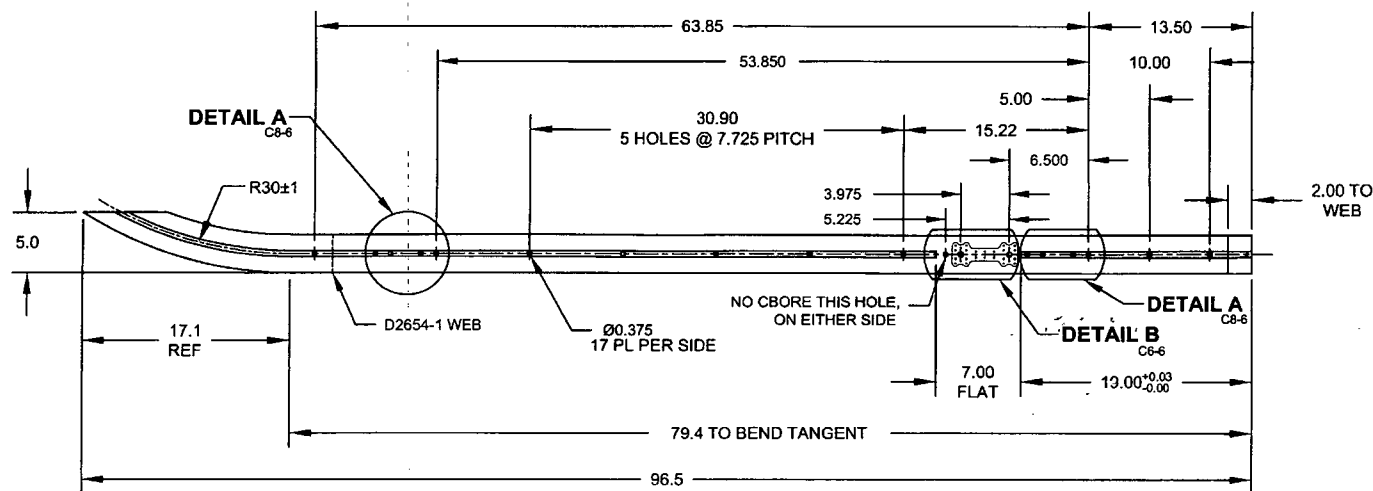
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

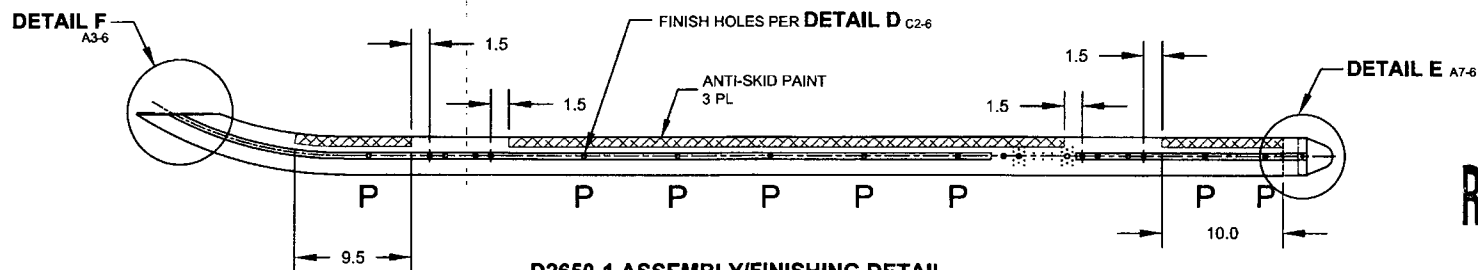
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
680722/107

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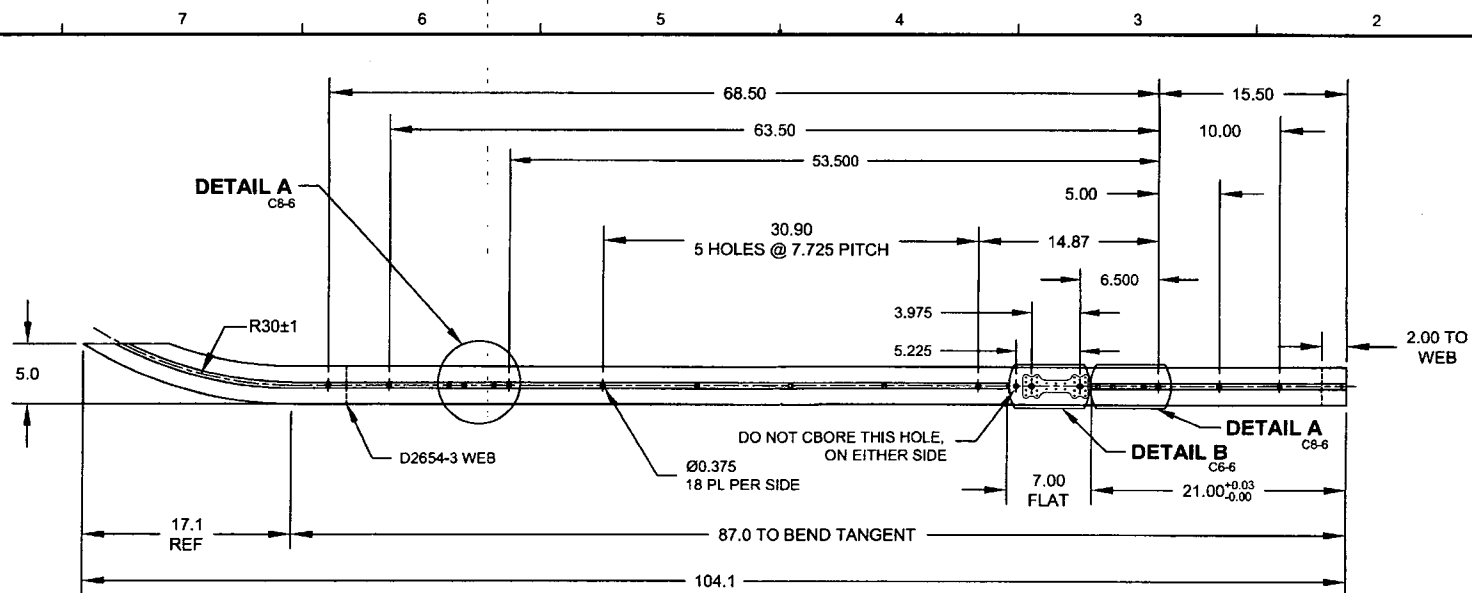
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

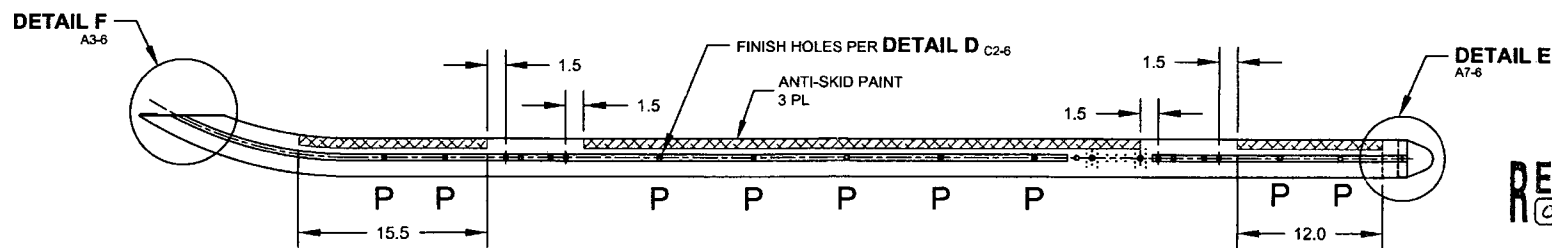
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
08-07-22-118

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CHECKED		DRAWING NO.	REV. F
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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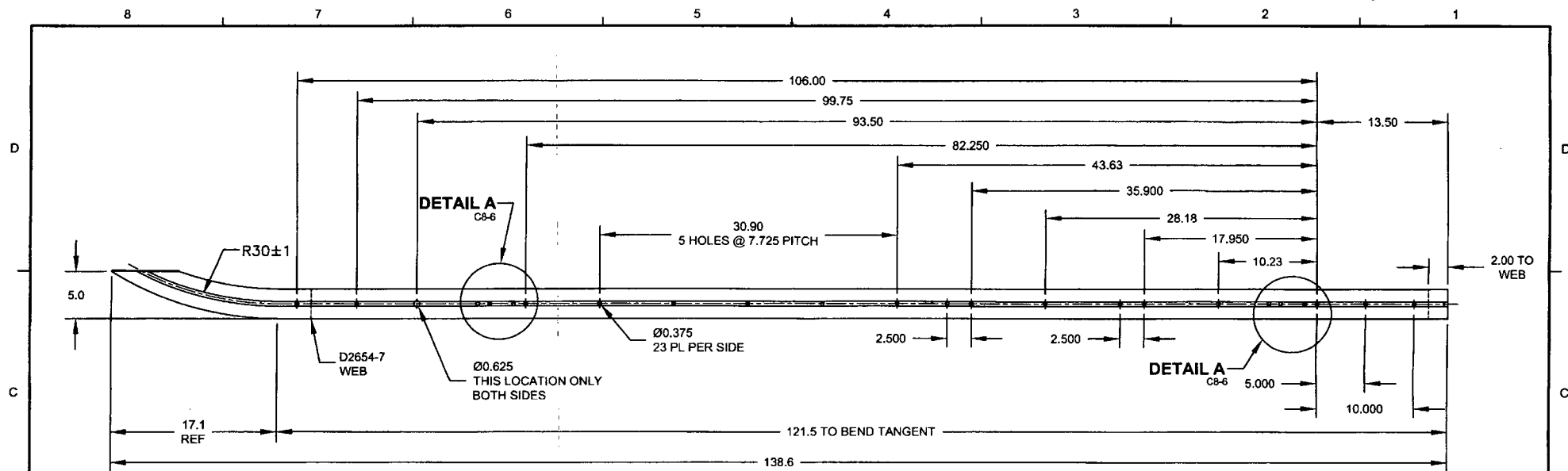
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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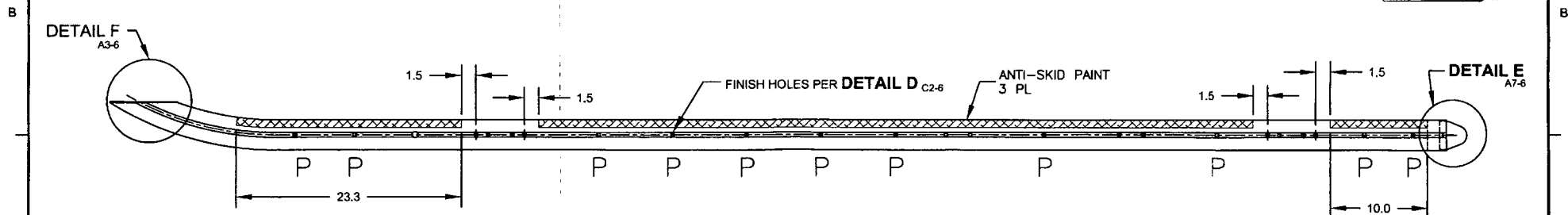
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69951



D2650-7 BENDING/DRILL DETAIL

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D2650-7 ASSEMBLY/FINISHING DETAIL

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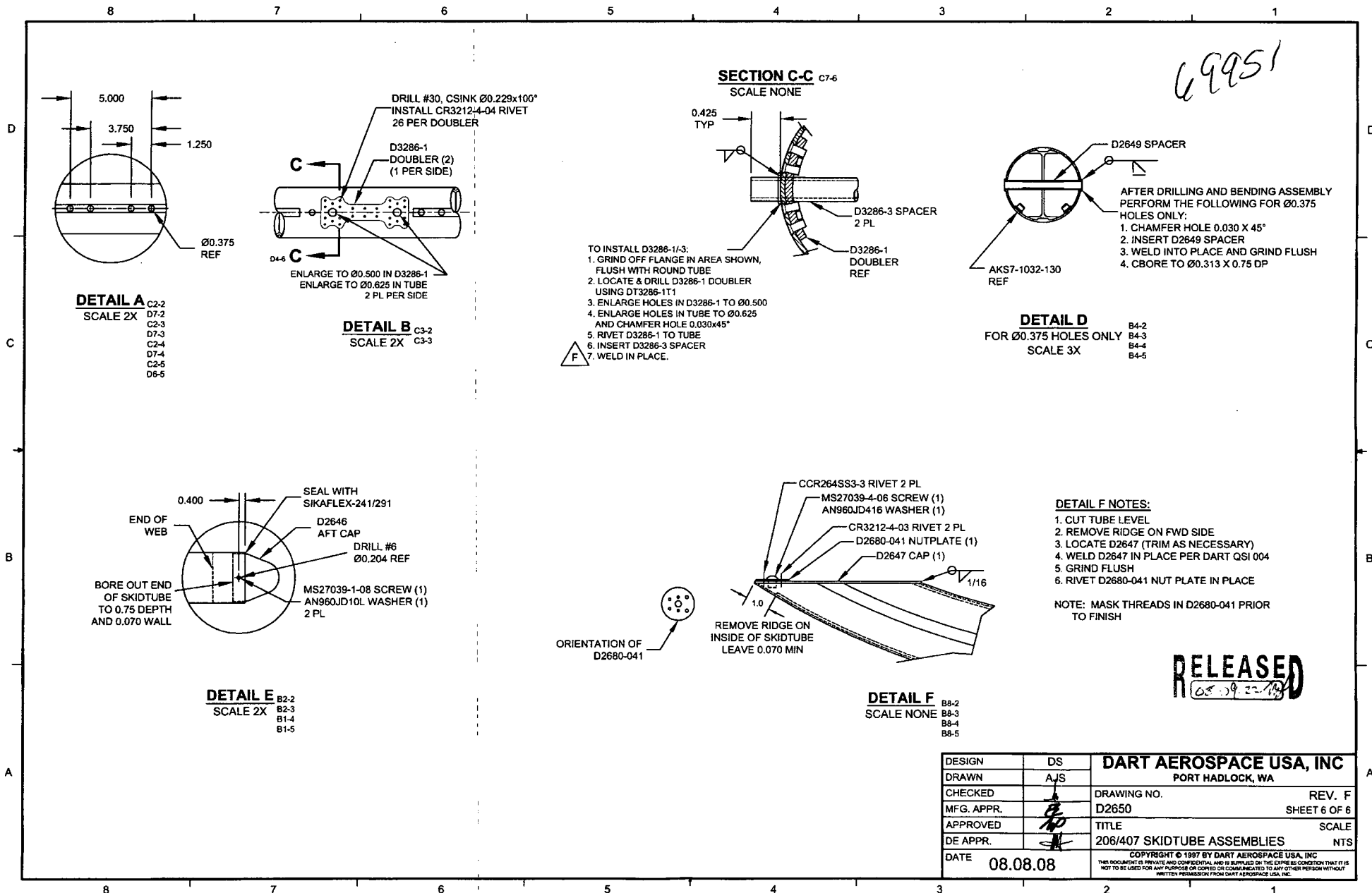
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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MFG. APPR.		D2650	SHEET 6 OF 6
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NOTE: Date & initial all entries

NO. 252

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 66358
Part number: D206 642 541
Description: D206
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Burns Date of Test Coupon 11-05-09

Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld